

5/43

DART AEROSPACE LTD	Work Order: 24633
Description: Wearplate	Part Number: D3321-1
Dwg: D3321 Rev. A page 1	Qty: 10
B 05.10.21 JPH	Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JPH	05.10.21	10
2	PG	Issue P/O: 2008213 Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3321 Possible Supplier: Industrial Laser Material release note is required	U	05.06.10	10
3	RG	Receive and inspect for transit damage Ensure material release note is attached	CL	05/10/21	10
4	QC6	Inspect dimensions as per inspection template D3321-1T1	DB	05.11.17	10
5	GA	Deburr if necessary	N/A		
6	GB	Form using DT8179 Die as per Dwg D3321 Dwg Rev: B	SB	05/11/17	10
7	QC6	Inspect dimensions as per Dwg D3321		05.12.01	10
8	WS	Weld hard surface using D3321-1T3 as per QSI 004 and Dwg D3321 Dwg Rev: B Qty Part Number Description Batch A/R N/A 7560 Hardcoat Rod M19174	CPL	05.12.21	10
9	QC9	Inspect weld	AA	05/12/21	10
10	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	ML	06.01.12	10
11	QC3	Inspect Powder Coat		06.01.13	10
12	ST	Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3321-1, B/N: BXXXXX For Product Eligibility see PDA04-17 and Stock Loc 73		06/01/13	10
13	AC	Cost / part:	U	06.01.13	
14	DC	Close W/O Inspect Level 21		06/01/16	10

Rev	Date	Change	Revised By	Approved
A	05.05.12	New issue	KJ/JLM	

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

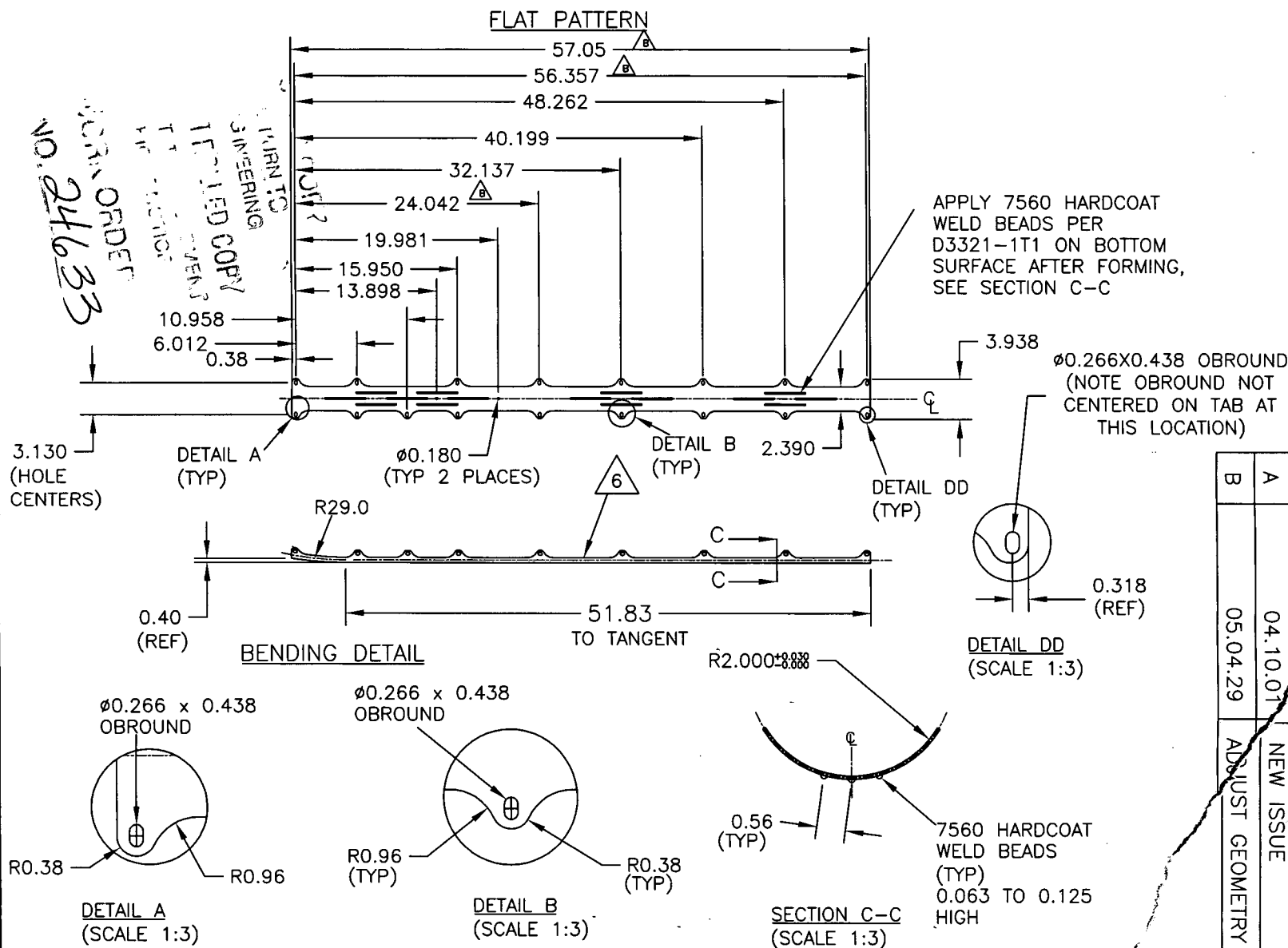
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/01/16

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

PRELIMINARY ISSUE



D3321-1 WEARPLATE (SHOWN, -2 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3321-X B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN	DRAWN BY	DART AEROSPACE LTD
D3321	PH	HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3321
DATE	TITLE	SHEET 1 OF 2
05.04.29	WEARPLATE	SCALE 1:15
A	NEW ISSUE	
04.10.01		
B	ADJUST GEOMETRY	
05.04.29		

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 20, 2005
04:09 pm

Work Order No : 0024633
Project Name : D3321-1
Project For : WK543
Work Order Type : Main
Main WO Number :
House Part Number : D3321-1
Description : Wearplate, LH Fwd RH Mid
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 10-20-05
Est Finish Date : 10-31-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Date: Friday, 11/18/2005 7:38:18 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 24633		
Estimate Number	: 10757		
P.O. Number	:	Part Number	: D33211
This Issue	: 11/18/2005 S.O. No. :	Drawing Number	: D3321 REV. B
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: 23343	Material	:
Written By	:	Due Date	: 11/25/2005 Qty: 10 Um: Each
Checked & Approved By	:		
Comment	: Est: A 05.05.12 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: _____

Email or Ship DXF file to vendor

Laser Cut flat pattern per Dwg D3321

Possible Supplier: Industrial Laser

Material release note is required

2.0

D33211F

Wearplate, LH Fwd RH Mid



Comment: Qty.: 1.0000 U(s)/Unit Total : 10.0000 U(s)

WEARPLATE

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per inspection template D3321-1T1

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 7:38:18 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 24633

Part Number: D33211

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1- Form using DT8179 Die as per Dwg D3321 Rev: _____

7.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3321-1T3 as per QSI 004 and Dwg D3321 Rev: _____

Qty	Part Number	Description	Batch
A/R	N/A	7560 Hardcoat Rod	_____

9.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

10.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

12.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3321-1, B/N: BXXXXX

For Product Eligibility see PDA04-17

and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 7:38:18 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 24633

Part Number: D33211

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:41 pm

Work Order No	: 0024633	Department Code:	
Project Name	: D3321-1	Burden Flags	: NNNNNNNN
Project For	: WK543	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D3321-1	Invoice Number	:
Description	: Wearplate, LH Fwd RH Mid	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 10	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 10-20-05		
Est Finish Date	: 10-31-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====					
Burden	: 0.00	0.00	0.00		
=====					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00